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5/29

DART AEROSPACE LTD	Work Order:	23636
Description: STA 84 bracket	Part Number:	D2803-2
Dwg: D2803 rev. <i>3/21</i>	Qty:	10

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue W/O	<i>JA</i>	05.06.21	10
2	METAL	Cut blanks per template DT 8533 Material: 6061-T6 bar 10.00" x 0.50"	<i>4/1</i>	05/06/21	8/2
3	HAAS	Machine as per folio FA102	<i>SD</i>	05.06.28	10
4	QC	Inspect Level 2	<i>TSG</i>	05.08.02	10
5	QC	Inspect Level 8	<i>FM</i>	05/08/02	10
6	METAL	Tumble & Deburr	<i>TSG</i>	05/08/02	10
7	QC	Inspect Level 5	<i>FM</i>	05/08/02	10
8	FINISHING	Chemical conversion coat per QSI 005	<i>FF</i>	05.08.02	10
9	STORES	Identify and stock	<i>DL</i>	05/08/03	10
10	EXPEDITING	Close W/O Cost / part: <del>407.77</del> 99.42 <i>SUC 05/08/10</i> <i>(10)</i>	<i>JA</i>	05/08/04	10

Rev	Date	Change	Revised By	Approved
A	00.11.06	New Issue	EC	<i>JA</i>

RELEASED

EC 00.11.06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   D   Date: 05/08/04

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	23636
<b>Description:</b> Bracket		<b>Part Number:</b>	D2803-2
<b>Inspection Dwg:</b> D2803	<b>Rev:</b> B	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.757	+0.005/-0.000	Ø.757	/			
1.420	+/-0.001	1.420	/			
Ø0.191	+0.005/-0.000	Ø.191	/			
Ø0.507	+0.000/-0.001	.507	/			
Ø0.507 x 0.250	+0.000/-0.001	Ø.507 x .254	/			
12.411	+/-0.010	12.410	/		TAPE	
13.558	+/-0.010	13.560	/		TAPE	
6.933	+/-0.010	6.932	/			
0.250	+/-0.010	.252	/			
0.875	+0.000/-0.005	.8745	/			
0.250	+0.000/-0.005	.246	/			
0.125	+/-0.010	.135	/			
0.125	+/-0.010	.135	/			
0.500	+/-0.010	.497	/			
0.125	+/-0.010	.125	/			
0.188	+/-0.010	.189	/			
0.562	+/-0.010	.560	/			
0.125	+/-0.010	.135	/			

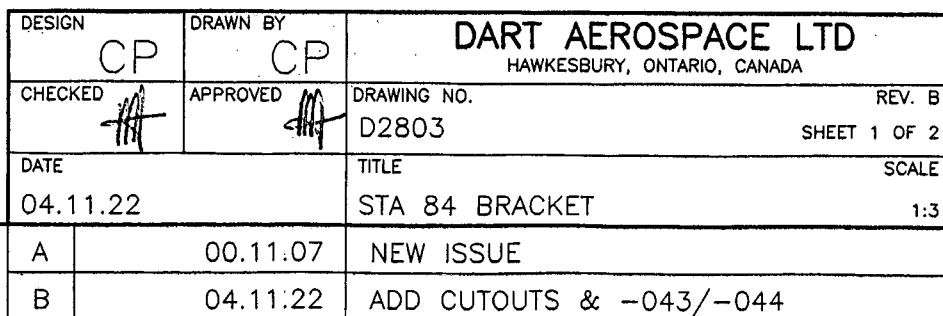
<b>Measured by:</b>	SD
<b>Date:</b>	05.06.28

<b>Audited by:</b>	EP
<b>Date:</b>	05.07.15

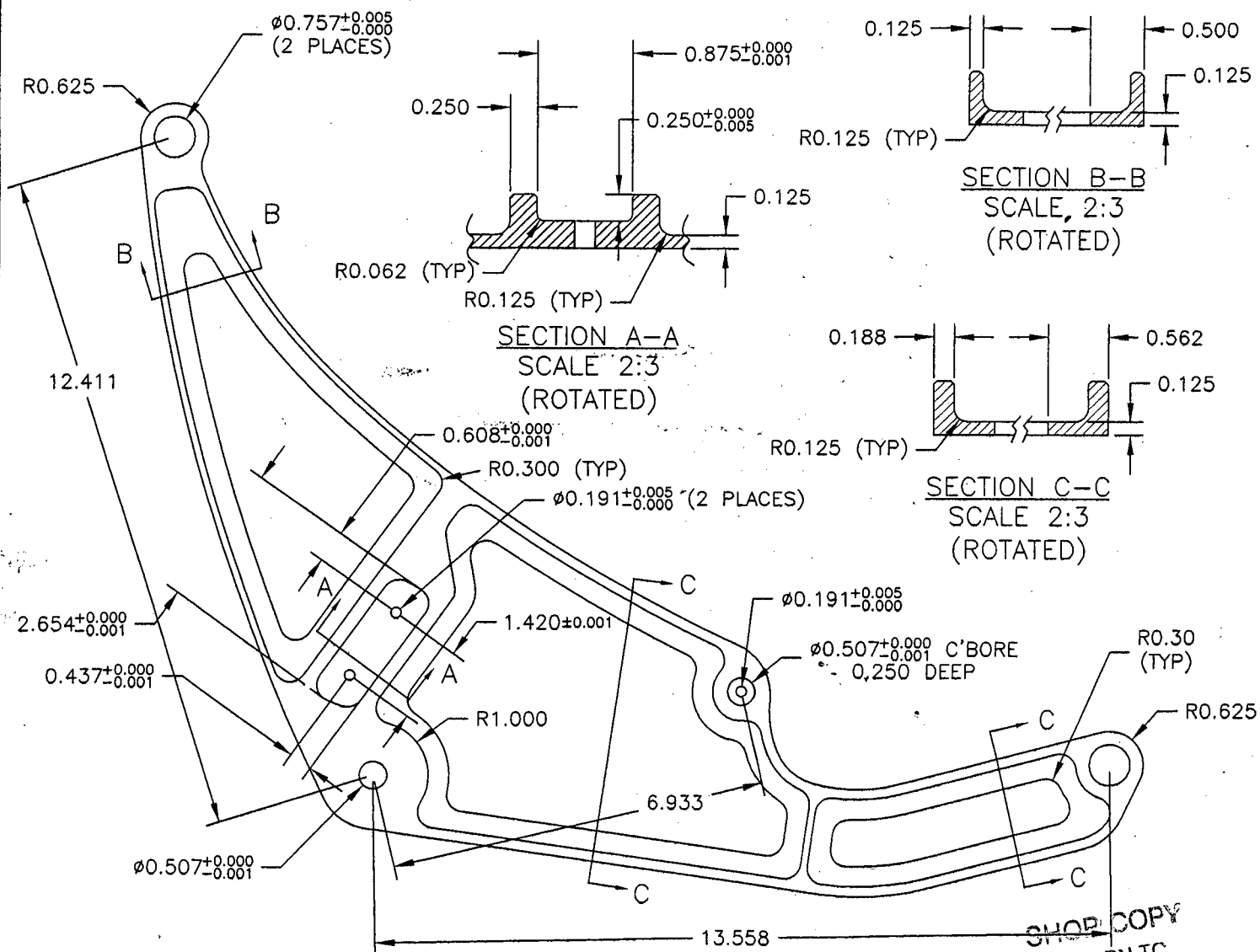
<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	

**RELEASED**  
14.05.03



05.03.11



D2803-1 BRACKET (SHOWN), D2803-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"  
2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK  
3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES  
4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE

WORK ORDER  
NO. 23636

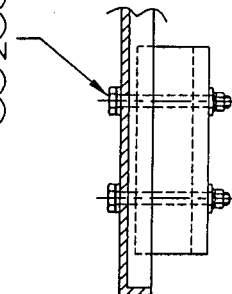
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22	TITLE STA 84 BRACKET		SCALE 1:3

AN3C16A BOLT (1)  
NAS1515H3 WASHER (2)  
MS21043-3 NUT (1)  
INSTALL BOLT WITH LPS-3 CORROSION  
INHIBITOR (ENSURE NO LPS-3 ON THREADS)  
(2 PLACES)



SECTION D-D  
SCALE 1:3  
(ROTATED)

USE D2803-1 FOR D2803-041/-043  
USE D2803-2 FOR D2803-042/-044

USE D2805-1 FOR D2803-041  
USE D2805-2 FOR D2803-042  
USE D2805-3 FOR D2803-043  
USE D2805-4 FOR D2803-044  
PRESS INTO PLACE PRIOR TO POWDER COAT

PRESS D2809 INTO PLACE  
PRIOR TO POWDER COAT

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WORK ORDER  
NO. 23636

D2803-041/-043 BRACKET ASS'Y (SHOWN).  
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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## Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Jun 20, 2005  
03:23 pm

Work Order No : 0023636  
Project Name : D2803-2  
Project For : WK529  
Work Order Type : Main  
Main WO Number :  
House Part Number : D2803-2  
Description : STA 84 Bracket  
Manufactured : Yes  
Amount Req'd : 10  
Amount Done : 0  
Start Date : 06-20-05  
Est Finish Date : 07-23-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
  
Order Entry No :  
OE Value : 0.00  
  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00